

# Work Order ID 74071

Wednesday, September 21, 2011 10:30:10 A



Page 1

Item ID: D350-591-213

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop



Start Date: 9/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-08-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100



DC

Document Control

DOCUMENT CONTROL

*50*

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

*11-11-24*  
*465 MJS*

110



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078  
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.  
3-Deburr

*11.10.04*

*4*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00	<i>Pl 11-10-04</i>			<i>4x</i>			
130  Large Fab Large Fab	Large Fab  Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod <i>114514</i> 3-Grind End Plate flush <i>118735</i>	0.00  0.00				<i>4</i>	<i>0</i>		<i>Pl 11-10-13</i>
140  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				<i>4</i>	<i>0</i>		<i>Pl 11/10/14</i>

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Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 11/10/14

(14)

4X 5m 11/10/17

4h 1 11/10/17

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200



Large Fab

Large Fab

0.00

11.11.22

4

0

**Memo**

0.00

Large Fab

1- Rivet Leg Assembly as per Dwg D3078.  
2-Bevel Aft end for welding  
3-Inspect for foreign object as per QSI 024  
4-Weld Aft End Plate as per QSI 004 & Dwg D3078  
A/R Aluminum Rod 114514  
5-Grind End Plate flush

210



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

11/11/22

**Memo**

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

11/11/22

**Memo**

24

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H BL 11-11-22

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00  
320 °F  
11:30

250

Wing Walk as per dwg QSI005 4.4 Batch 118928

0.00



HandFinish

Memo

0.00

Hand Finishing

4X J M / 11/11/23

H. BL 11-11-23

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Stop



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4xhkl f ul 11/11/23  
COUNTED x MEASURED

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ul 11/23 (4)

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

ul 11/25

24  
47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-213 Location: _____ PPP Rev: _____								
300  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/11/2011

11/11/2011

ME

11-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, September 21, 2011 10:30:15 AM

Work Order ID: 74071

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH



Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D  
 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified  
 by:JLM IPP Rev:E  
 10.11.15 update qty on AN4-11A DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C 		Manufactured	No			110	Each	145.2000	0.5	2		11.10.04	
Step Extrusion													

Location	Loc Qty	Loc Code
HALL	135.5	
64409	6	
68293	22.5	
72131	107	
WA	9.7	
46910	2	
66970	7.7	

D3067-1 	Manufactured	No				130	Each	143.0000	1	4		11.10.08	
End Plate													

Location	Loc Qty	Loc Code
WA	142	
67582	2	
73404	140	
WA016	1	
68214	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

D3063-1 Manufactured No  
Support

130 Each 78.0000



1 4  
11.10.08

Location	Loc Qty	Loc Code
WA	78	
66182	18	
71886	60	

MS20600-AD4W4 Purchased No  
Rivets

180 Each 3,334.000



16 64  
11.11.22

Location	Loc Qty	Loc Code
ST321	3329	
116188	59	
117364	875	
117601	200	
117885	195	
118840	2000	
WA018	5	
116712	5	

D3066-1 Manufactured No  
Spacer

180 Each 47.0000



2 8  
11.11.22

Location	Loc Qty	Loc Code
WA 375076	47	
70699	47	

D3065-041 Manufactured No  
Step Leg Assembly Hi

180 Each 0.0000



1 4  
11.11.22

376194 = 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

D3067-1

Manufactured No

200

Each

143.0000

1

4



End Plate



11.11.22

Location

Loc Qty

Loc Code

WA

375468

142

67582

2

73404

140

WA016

1

68214

1

4

AN3-35A

Purchased No

270

Each

203.0000

2

8



Bolt



8

Location

Loc Qty

Loc Code

ST353

203

117619

3

117794

3

118112

1

118451

46

118628

50

118838

100

8

D2856-400

Manufactured No

270

f

199.3845

0.6

2.4



Abraison Strip



11/12/2011

Location

Loc Qty

Loc Code

ST403

0.3149

68076

0.3149

ST409

199.0696

63735

0.6696

71164

198.4

✓

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

measured 5/11/12

W/O:		WORK ORDER CHANGES					
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Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-11A

Purchased

No

270

Each

264.0000

2 8



Bolt

## Location

## Loc Qty

## Loc Code

ST356

100

117872

100

ST357

164

110382

1

115316

63

118706

100

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

0.0000

12 48



Washer

D2230-1

Manufactured

No

270

Each

297.0000

2 8



Lug

## Location

## Loc Qty

## Loc Code

ST470

100

72811

100

ST476

197

67826

6

69821

91

70974

100

W/O:		WORK ORDER CHANGES					
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Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

270

Each

2,592.000

2 8



Nut

MIROTS

Location

Loc Qty

Loc Code

ST300

2592

117441

24

117601

363

117885

205

118451

1000

118927

1000

AN4-13A

Purchased

No

270

Each

1,766.000

4 16



Bolt

16

Location

Loc Qty

Loc Code

ST357

1766

118078

594

118351

172

118706

500

118838

500

D2732

Manufactured

No

270

f

521.8981

1

4.210526



Rubber Extrusion

16

11/11/23

Location

Loc Qty

Loc Code

ST410

521.89811

64283

23.02811

70987

498.87

cut qty of 4 at 3.00" as per dwg(D2732-030)

W/O:		WORK ORDER CHANGES					
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Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 4.00

Required Qty: 4.00

D2230-3

Manufactured No

270

Each

186.0000

2 8



Lug



B74440

## Location

## Loc Qty

## Loc Code

ST

181

71964

81

72125

100

ST476

4

53881

4

ST480

1

70973

1

AN960JD10

NAS1149D0363J

Purchased

No

270

Each

0.0000

4 16



Washer

MS21042L4

Purchased

No

270

Each

4,297.000

6 24



Nut



M119017

## Location

## Loc Qty

## Loc Code

ST300

4297

117441

51

117601

637

117885

609

118451

2000

118927

1000

AN4-16A

Purchased

No

270

Each

132.0000

4 16



Bolt



M11123

## Location

## Loc Qty

## Loc Code

ST358

132

117872

82

118838

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED  
02.01.20 *CP*

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NO. 74071 *R 110921*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

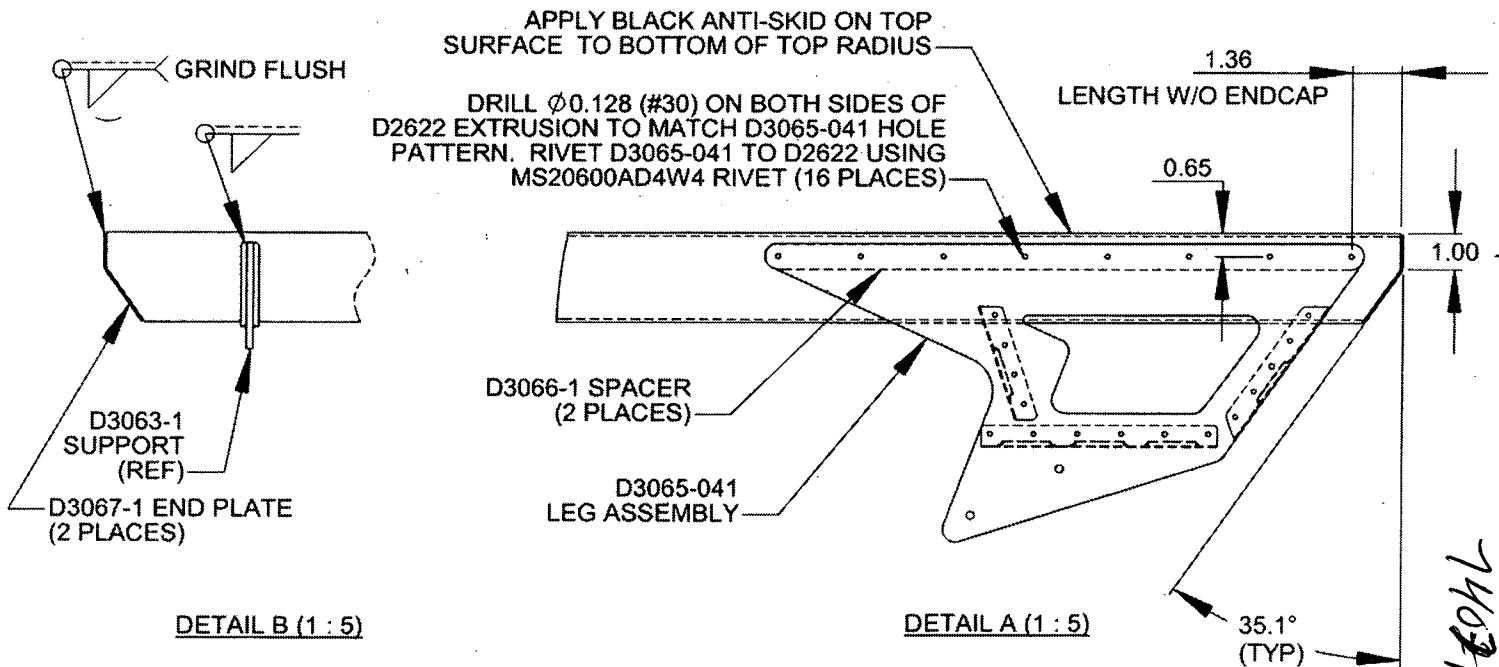
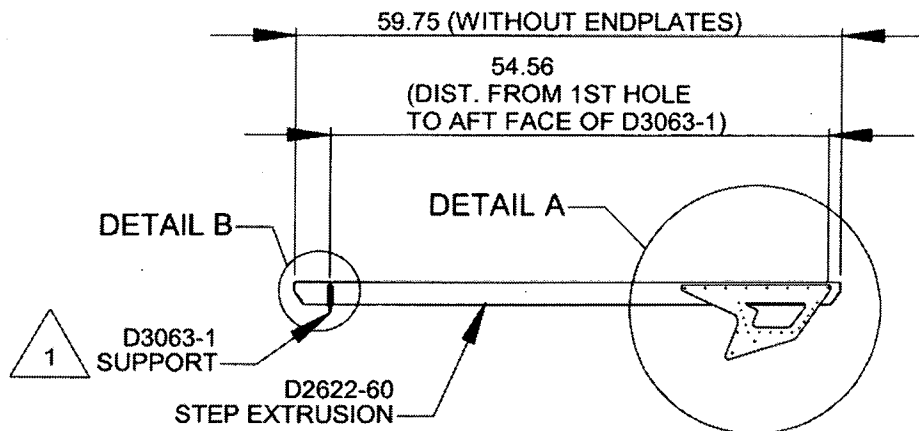
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		TITLE	SHEET 2 OF 2
02.09.11		STEP ASSEMBLY, HI SHORT	SCALE 1:20

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02.09.2004



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

### ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

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WORK ORDER  
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CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-Q-01

APPROVED  
BY: [Signature]  
D. SHEPHERD (DE # 02)  
DATE: 09.08.05  
CERT. NO.: SH92-6  
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>92</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>LP</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>NCA</u>	DSI 9472	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	BOLT ADDITION	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

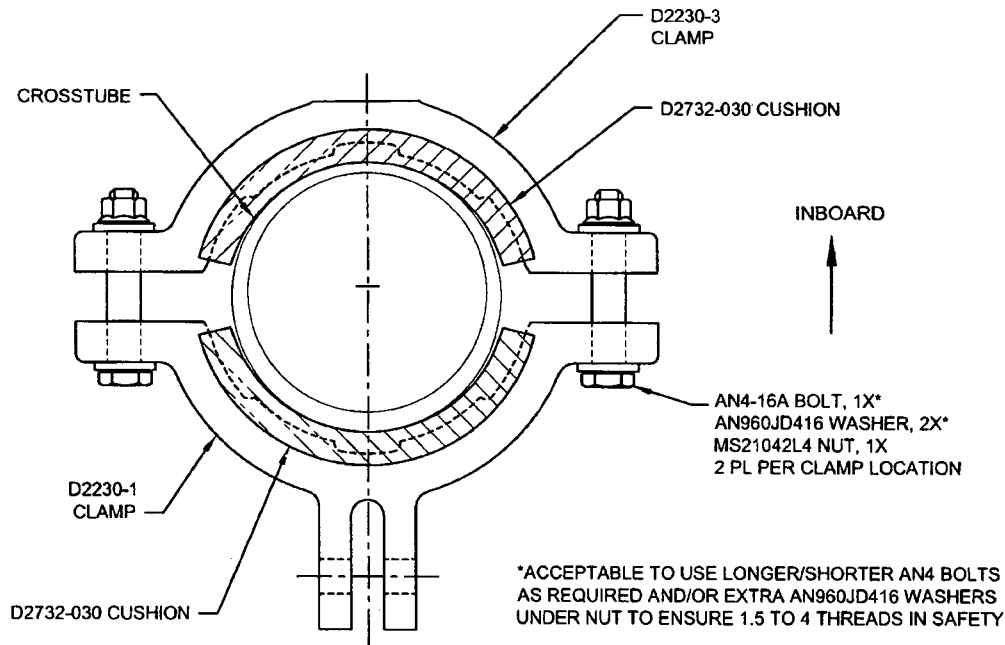
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**FIGURE 1: CLAMP DETAIL**  
**OPTIONAL CLAMP CONFIGURATION**

74071

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.08.05  
CERT. NO.: SH92-6  
ISSUE NO.: 11

DESIGN	<i>GP</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
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DE APPR.	<i>[Signature]</i>	BOLT ADDITION	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## DART AEROSPACE LTD.

REFERENCE ONLY

D350-591

Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

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



### ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
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	X			D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
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